

Date: Friday, 11/18/2005 6:53:16 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 24851					
Estimate Number	: 10764					
P.O. Number	: N/A			Part Number	: D2876	
This Issue	11/18/2005	S.O. No.	: N/A	Drawing Number	: D2876 REV A	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	N/A	Type	MACHINED PARTS	Drawing Revision	: A	
Previous Run	: N/A			Material	: NOTE: 1 BLANK MAKES 4 PARTS	
Written By	: See comment below			Due Date	12/21/2005	Qty: 120 Um: Each
Checked & Approved By	: See comment below					
Comment	: Esr Rev:B 00.05.19 Added inspect level 8 EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S100	5052-H32 .100 Sheet
		Comment: Qty.: 0.0542 sf(s)/Unit Total: 6.5016 sf(s) Material: 5052-H32/H34 (QQ-A-250/8) 0.100" Thick Batch: M15538
2.0	SHEAR	SHEAR
		Comment: SHEAR 1 blank makes 4 parts Blank: 7.00" x 4.25" (+0.030" - 0.000")
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1
		1-Machine per folio D2876
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK

WO:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes Yes No No DQA: S Date: 06/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 6:53:16 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE SPACER
Job Number: 24851		Part Number: D2876
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Tumble		DL 05/12/19 120
7.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 384		
10.0	DC 	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21		
Sur 26/11/03		(120) 05/01/03 (120)
Job Completion 		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

0000000000

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	:	0024851	Department Code:
Project Name	:	D2876	Burden Flags : NNNNNNNN
Project For	:	WK550	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D2876	Invoice Number :
Description	:	Saddle Spacer	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	120	
Amount Done	:	0	Order Entry No :
Start Date	:	11-17-05	OE Value : 0.00
Est Finish Date	:	12-21-05	
Act Finish Date	:		Est Margin : 0.000%
Drawings Reqd	:	No	Actual Margin : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

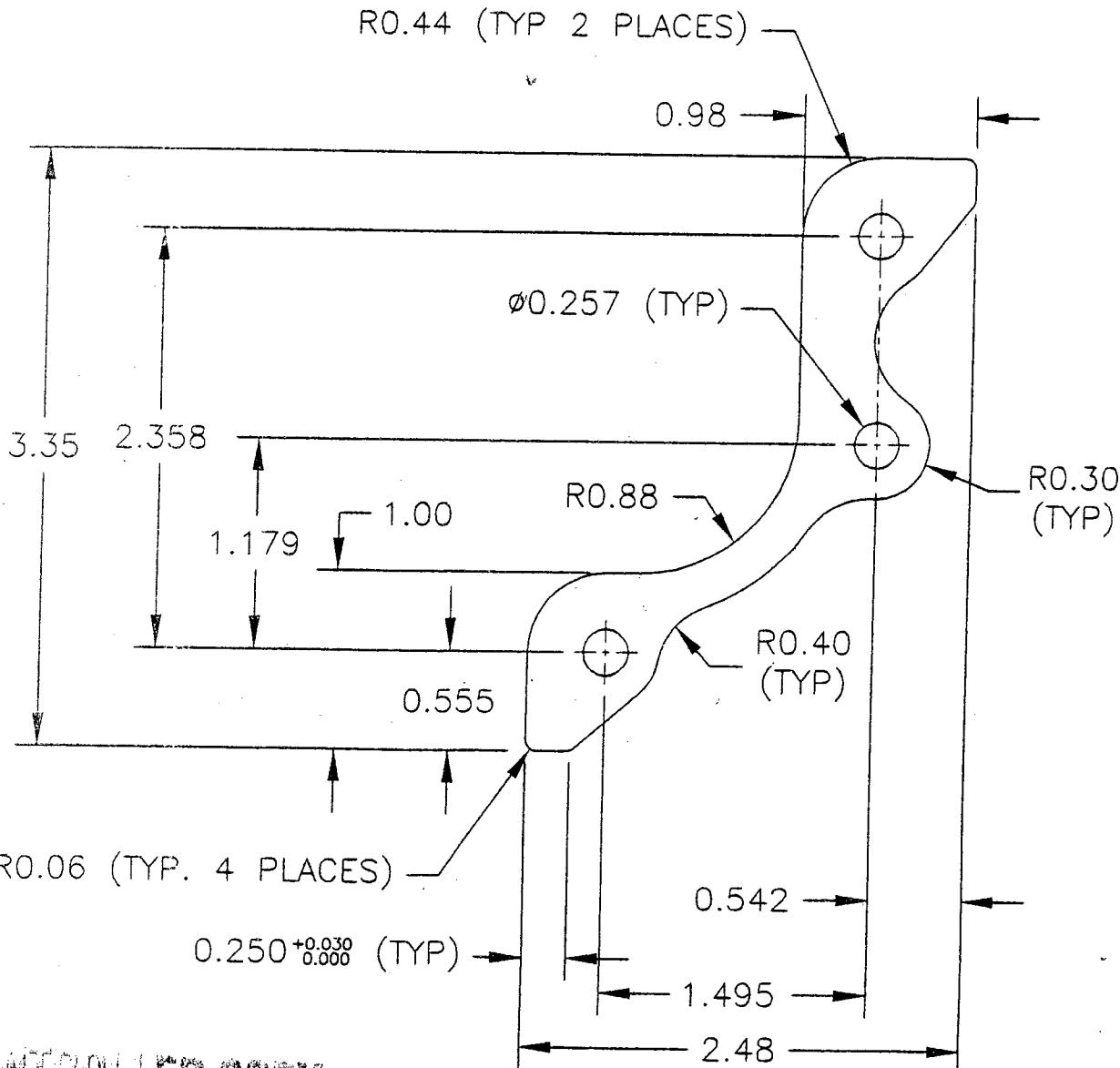
	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
	=====	=====	=====		
Burden	:	0.00	0.00	0.00	
	=====	=====	=====		
Total Cost	:	0.00	0.00	0.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual
Labour Hrs/Amount Done	:	0.00
Profits/(Loss)	:	0.00



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2876
DATE		REV. A SHEET 1 OF 1 SCALE 1:1
99.02.23		TITLE SADDLE SPACER
A	99.02.23	NEW ISSUE

RELEASED  
99.04.27 DS



CONTROLLED COPY

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.100 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL SHARP EDGES 0.010 TO 0.020

DART AEROSPACE LTD.	Work Order:
Description: SADDLE SPACER	Part Number: 24857
Inspection Dwg: D2876 Rev: A	D2876 Page

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

Measured by: Esp  
Date: 05/12/11

Audited by:	<i>ml</i>
Date:	05/12/11

Prototype Approval:	
Date:	

Rev	Date	Change
A		New Issue

—

Revised by  
KURE

First Article

## Prototype

Measured by:	
Date:	

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	